



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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C3-19C

Job Sheet 191946



Part No: C3-19C

Job Qty: 3 pcs

DAS
21
9-89

Part Name: C3 Cage



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/13/19

Job Tracking No:

Due Date: 3/19/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG C3-19C Rev 5 IPP Rev A 18.03.29 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Large Fab - Welded Assy-1	3 pcs	3/19/19		0.00	30.00	Large Fab - 1	
							Large Fab - 10	
							Large Fab - 2	
							Large Fab - 3	
							Large Fab - 4	
							Large Fab - 5	
							Large Fab - 6	
							Large Fab - 7	
							Large Fab - 8	
							Large Fab - 9	
110	QC 9	3 pcs	3/19/19		0.00	0.00	QC 9 - 10	DAS 43 9-89
							QC 9 - 18	
							QC 9 - 24	
							QC 9 - 43	
							QC 9 - 50	
							QC 9 - 9	
120	QC 5	3 pcs	3/19/19		0.00	0.00	QC 5 - 10	DAS 43 9-89
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 42	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	



Container No: S162582



Part: C3-19C

Job No: 191946

Serial No/Batch: S162582

Revision: 5

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
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Date: 03/14/19

					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
130	Powdercoat - 6 Fire Red - B4B	3 pcs	3/19/19	0.00 1.50	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BK19-03 2x
					Powdercoat - 4 - B4B	
140	QC 3	3 pcs	3/19/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	DAS
					QC 3 - 28	28
					QC 3 - 3	9-89
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
150	Packaging 3-1 - Stock - B4B	3 pcs	3/19/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	

				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	3 pcs	3/19/19	0.00 0.00	QC 21 - SA - 21	046
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-00 MAR 27 2019

Part Op **100** - Fabricate per Drwg - 1-MANUFACTURE AS PER DWG, TACK WELD FOR INSPECTION BY: _____ USE
 Descriptions: WELDING JIG C3-19C. 2-Weld as per DWG. ***SEE NOTE 1, ALL HOLES MUST ALIGN***
110 - QC9- Inspect visual per QSI004- Fusion Welds
120 - QC5- Inspect part completeness to step on W/O
130 - Fire Red(Ref:4.3.5.10) per QSI005 4.3 START TIME: 8:45 OVEN TEMPERATURE: 320° FINISH TIME: 9:15 M129203
140 - QC3- Inspect Part Finish
150 - Identify as per dwg & Stock Location: _____
160 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
C3-18-1	Lifting Plate	6 pcs (2 ea)	100-Large Fab - Welded Assy-1	<u>5144716</u>
C3-18-5	Boss	6 pcs (2 ea)	100-Large Fab - Welded Assy-1	<u>5116808</u>
C3-18-6	Bumper Bracket	3 pcs (1 ea)	100-Large Fab - Welded Assy-1	<u>5058911</u>
MT-A513-T-0.875W0.120	A513 Seamless Alloy Steel Round Tubing 0.875"dia. x 0.120" Wall	26.1000 ft (8.7 ea)	100-Large Fab - Welded Assy-1	<u>5113467</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	C3-18-1	6	8	0
	C3-18-5	6	40	0
	C3-18-6	3	3	0
	MT-A513-T-0.875W0.120	26	36	0

Part Specifications
Specifications could not be found.